CLAIMS

1. A can end comprising a peripheral cover hook, (23) a chuck wall (24) dependent from the interior of the cover hook, an outwardly concave annular reinforcing bead (25) extending radially inwards from the chuck wall, and a central panel (26) supported by an inner portion (27) of the reinforcing bead, characterised in that, the chuck wall (24) is inclined to an axis perpendicular to the exterior of the central panel (26) at an angle C between 30° and 60°, and the concave cross sectional radius of the reinforcing bead (25) is less than 0.75mm.

2. A can end according to claim 1 characterised in that the angle of the chuck wall (24) to the perpendicular axis is between 40° and 60°.

3. A can end according to claim 2 wherein the angle of the chuck wall (24) to the perpendicular axis is between 40° and 45°.

4. A can end according to any of claims 1 to 3 characterised in that an outer wall of the reinforcing bead is inclined to a line perpendicular to the central panel (26) of the can end at an angle between -15° and +15° and the height h_4 of the outer wall is up to 2.5mm.

5. A can end according to any of claims 1 to 4 characterised in that the reinforcing bead has an inner portion parallel to an outer portion joined by said concave radius.

6. A can end according to any preceding claim characterised in that the ratio of the diameter of the central panel to the diameter of the peripheral curl is 80% or less.

7. A can end according to any preceding claim characterised in that it is made of a laminate of thermoplastic polymer film and a sheet aluminium alloy or tinplate or electrochrome coated steel.

8. A can end according to claim 7 characterised in that the laminate comprises a polyethylene teraphthalate film on an aluminium – manganese – alloy sheet less than 0.010 (0.25mm) thick.

9. A method of forming a double seam between a can body (12) and a can end (22) according to any preceding claim, said method comprising the steps of:
placing the curl (23) of the can end on a flange (11) of a can body supported on a base plate (4); locating a chuck (30) within the chuck wall (24) of the can end, said chuck having a frustoconical drive surface (32) of substantially equal slope B° to that of the chuck wall of the can end and a substantially cylindrical surface portion (33) extending away from the drive surface; causing relative motion as between the assembly of can end and can body and a first operation seaming roll (34) to form a first operation seam, and thereafter causing relative motion as between the first operation seam and a second operation roll (38) to complete a double seam, during these seaming operations the chuck wall (24) of the can becoming bent to contact the cylindrical portion (33) of the chuck.

10. A method according to claim 9 characterised in that the substantially cylindrical surface portion (33) of the chuck is inclined at an angle between +4° and -4° to the longitudinal axis of the chuck.